









Work Order ID 72437

Monday, July 25, 2011 2:39:10 PM

Page 1

Item ID: D4018-041 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Short Basket Lid Assembly (350)
 Start Date: 7/25/2011 Start Qty: 1.00  Cust Item ID:
 Required Date: 8/8/2011 Req'd Qty: 1.00  Customer:
 Reference:

Approvals: Process Plan:  Date: 11-07-25 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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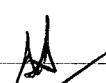
Draw Nbr	Revision Nbr
D4018	C

100 Weld per dwg A/R S.S. rod Batch: 1114649 0.00
 Large Fab

Large Fab Memo 0.00
 1- assemble ribs , weld as per dwg D4018 using DT9607B
 2- weld hinge (3) and Mounting brackets as per dwg D4018
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D4018
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00


QC Memo 0.00
 Quality Control


PMB 11/08/03
BE-11/08/03
11-08-03 1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72437

Monday, July 25, 2011 2:39:10 PM



Page 2

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

J ulozloy

Memo

0.00

④

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M115128

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 10:20am

Oven Temperature: 320°F

Finish Time: 10:50am

1 of 1 ulozloy

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

0.00

M118313

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- install label

1X of M-11/08/02

W/O:		WORK ORDER CHANGES					
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Work Order ID 72437

Monday, July 25, 2011 2:39:10 PM



Page 3

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP4/08/09 @

160

Identify as per dwg & Stock Location: *G.A*

0.00



Packaging

Memo

0.00

Packaging

w/o
72431

EP4/08/09 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CA 11/08/09
MF
11-08-09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:39:17 PM

Page 1

Work Order ID: 72437

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)




Start Date: 7/25/2011

Required Date: 8/8/2011


Start Qty: 1.00


Required Qty: 1.00


Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
per dwg revA 10.03.15 verified by:EC
DD 10.04.16 verified by:EC
IPP Rev:B as per dwg RevB
IPP Rev:C as per dwg RevB
IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>71996 - ①</div> <div>71992 - ①</div> <div> <div>Location</div> <div>WA</div> <div>71992</div> <div>71996</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>1</div> <div>3</div> </div> <div> <div>Loc Code</div> </div> </div>													
D4018-3  Rib		Manufactured	No			100	Each	6.0000	2	2			
<div> <div> <div>Location</div> <div>WA005</div> <div>68479</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> </div> </div>													
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	16.0000	3	3			
<div> <div> <div>Location</div> <div>WA005</div> <div>71941</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> </div> </div>													

3

 2
PMB 11/07/28

 2
PMB 11/07/28

 3
PMB 11/07/28

 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 25, 2011 2:39:17 PM

Page 2

Work Order ID: 72437

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5

Manufactured No

100

Each

34.0000

6

6



Rib



PMB 11/07/28

Location

Loc Qty

Loc Code

WA 72339

23

70758

5

71939

18

WA005

11

67041

11

6

D4035-041

Manufactured No

100

Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



PMB 11/07/28

Location

Loc Qty

Loc Code

WA

3

63720

0

71484

1

72088

2

3

D4035-043

Manufactured No

100

Each

0.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



PMB 11/07/28

D2581

Manufactured No

100

Each

63.0000

2

2



Mounting Bracket



PMB 11/07/28

Location

Loc Qty

Loc Code

WA

63

69258

28

69739

2

70766

33

2

Monday, July 25, 2011 2:39:17 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, July 25, 2011 2:39:17 PM

Page 3

Work Order ID: 72437

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-7

Manufactured No

100

Each

1.0000

1

1



Mesh (350 Basket Short, Lid)

B 71815



PMB

11/08/02

Location

Loc Qty

Loc Code

FG

1

68523

1

D4021-3

Manufactured No

100

Each

12.0000

1

1



Data Plate

B 71943



PMB - 11/07/28

Location

Loc Qty

Loc Code

WA

12

71943

12

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

M 115050



IX M-L 11/08/04

Monday, July 25, 2011 2:39:17 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

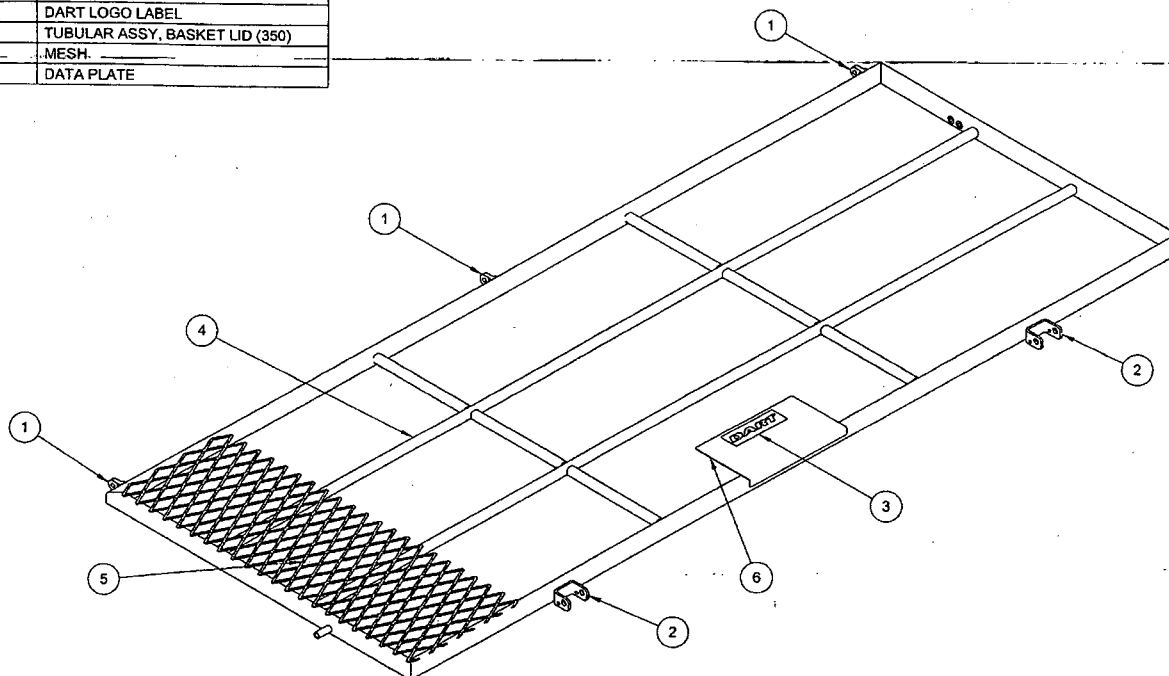
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHC
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
22437

R/110725

RELEASED
10.08.12
ECN 10-946

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4018
REV. C
SHEET 1 OF 4
TITLE SHORT BASKET LID ASSY (350)
SCALE NTS

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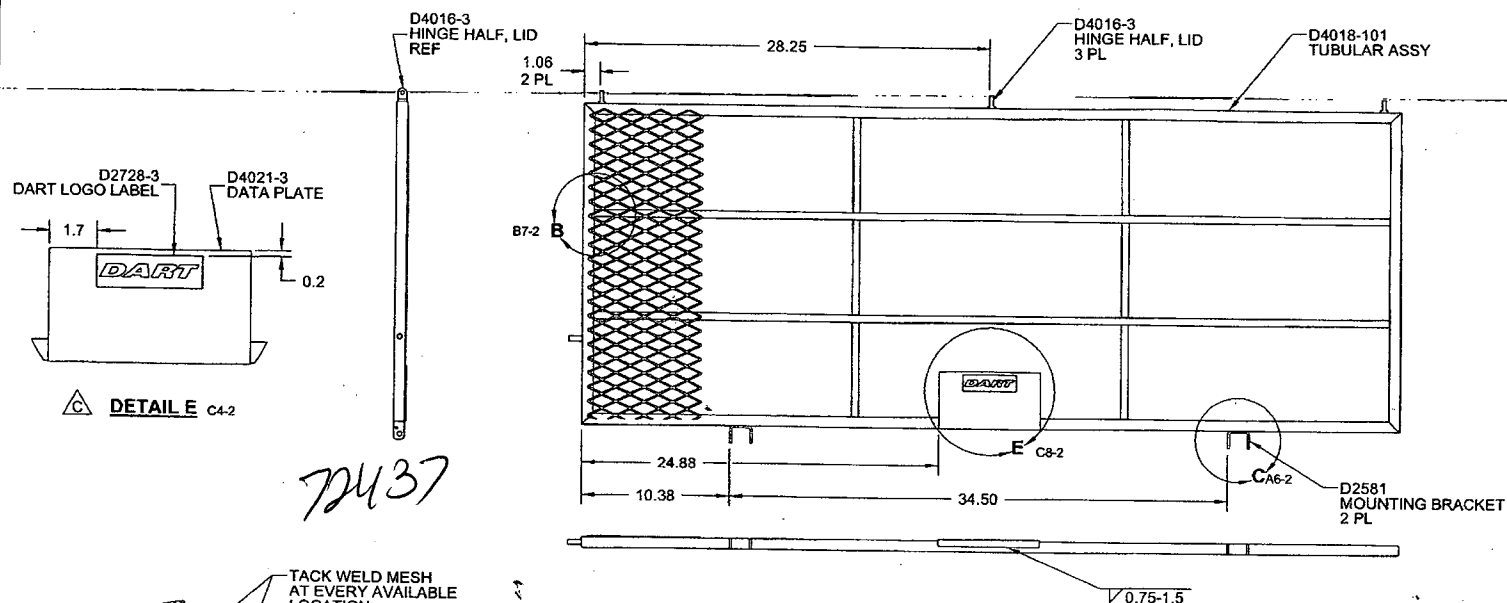
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

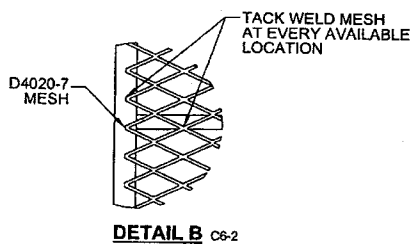
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

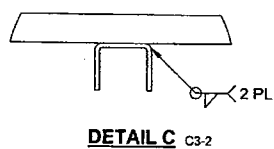
NOTE: Date & initial all entries



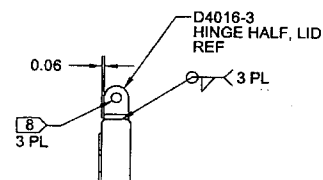
DETAIL E C4-2



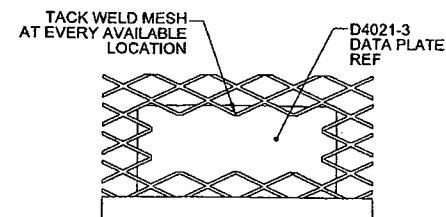
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR ANY DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
1068.12 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

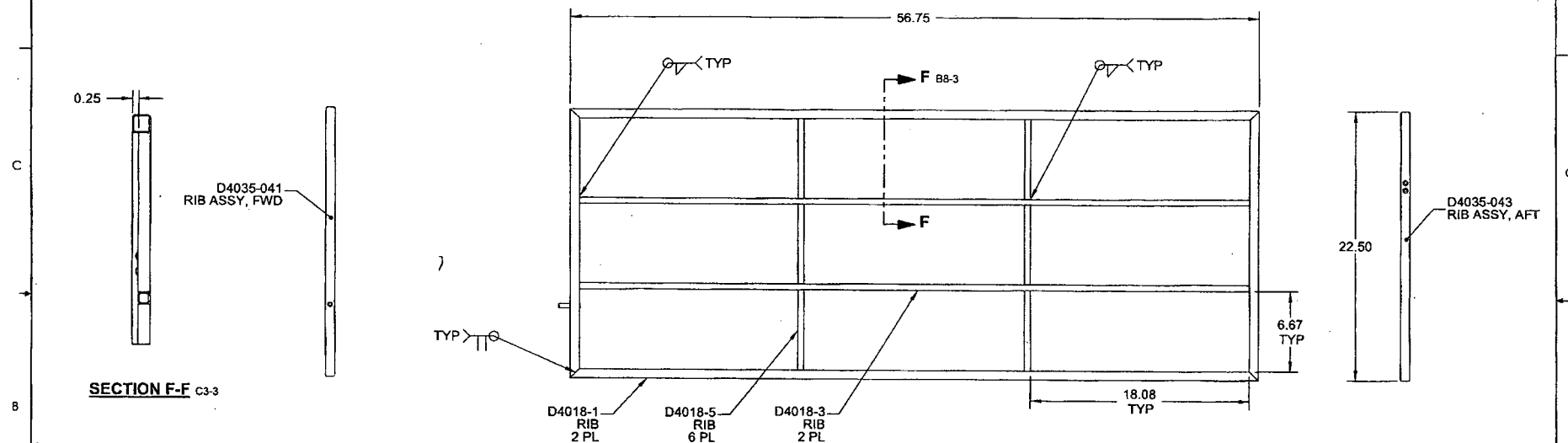
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 3 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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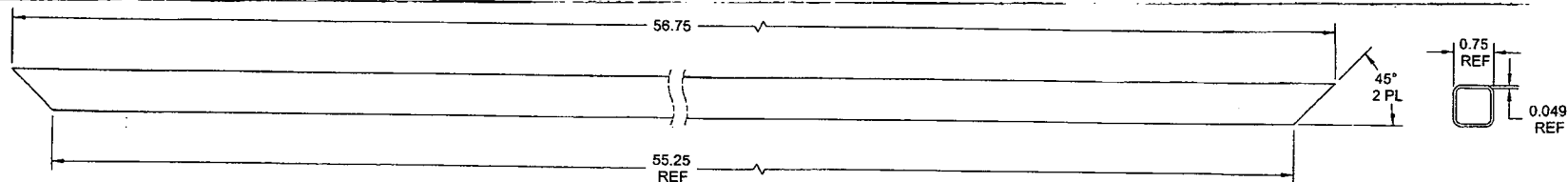
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

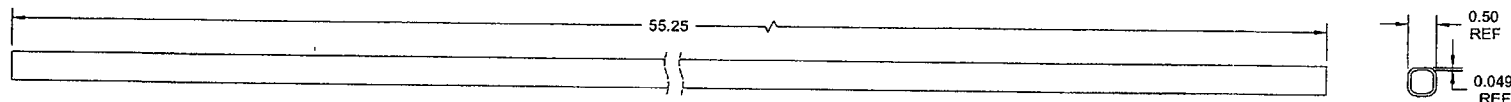
D



D4018-1 RIB

C

C

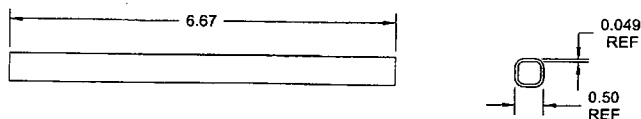


D4018-3 RIB

72437

B

B



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
18-08-12 UP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JSC	DRAWING NO.	REV. C
MFG. APPR.	JSC	D4018	SHEET 4 OF 4
APPROVED	JMS	TITLE	SCALE
DE APPR.	H	SHORT BASKET LID ASSY (350) NTS	
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8 7 6 5 4 3 2 1

A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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